

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000867**Date Inspected:** 19-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans Mock-Up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

The Caltrans QA Inspector observed the repair welding (Critical Weld Repair No. 007) of Piece Mark mp1004-2 stiffener to Piece Mark MA113 for the 114M Mock-Up Upper (Top) Plate Panel "D" Sub-Assembly. The weld was identified as MUSC-MA113-8 and is a complete joint penetration (CJP) groove weld welded in the flat (1G) welding position. The welder was Jiang Zhoo (Welder I.D. No. 040261). Welding Procedure Specification (WPS) 345-FCAW-1G(1F)-Repair, for Flux Cored Arc Welding (FCAW) was used for this weld. The Drawing No. is MUSC-MA113, Rev. 0 and the Member ID. is MA113 - mp1004-2.

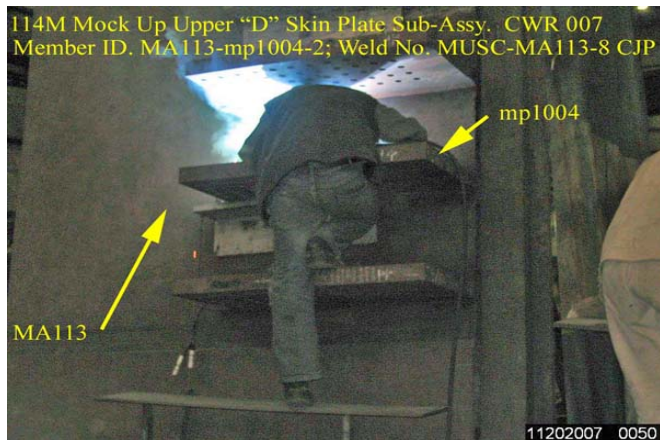
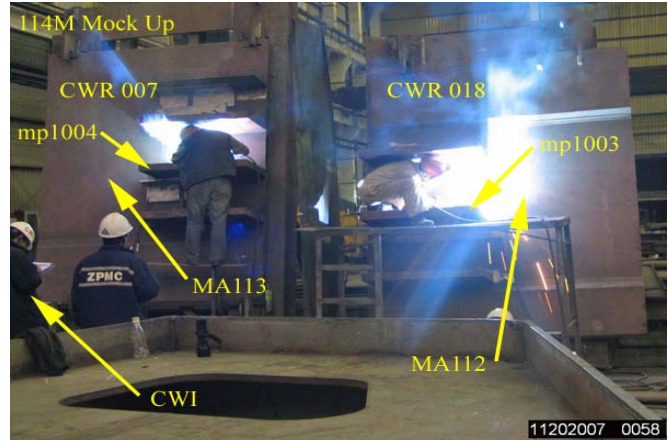
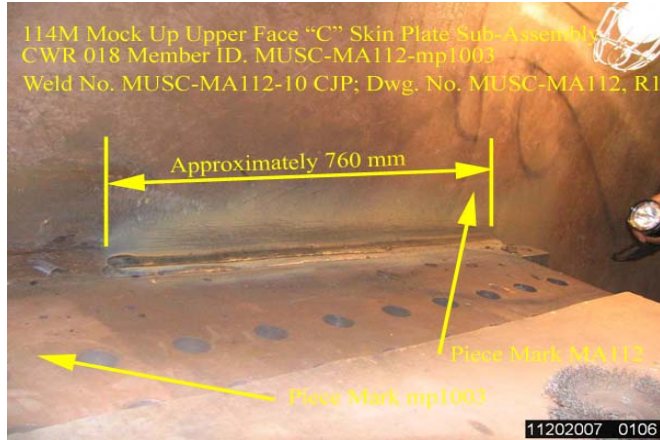
The Caltrans QA Inspector also observed the repair welding (Critical Weld Repair No. 018) of Piece Mark mp1003 stiffener to Piece Mark MA112 for the 114M Mock-Up Upper (Top) Plate Panel "C" Sub-Assembly. The weld was identified as MUSC-MA112-10 and is a complete joint penetration (CJP) groove weld welded in the flat (1G) welding position. The welder was Bai Wenming (Welder I.D. No. 040434). Welding Procedure Specification (WPS) 345-FCAW-1G(1F)-Repair, for Flux Cored Arc Welding (FCAW) was used for this weld. The Drawing No. is MUSC-MA112, Rev. 0 and the Member ID. is MA112 - mp1003.

ZPMC American Welding Society (AWS) Certified Welding Inspector (CWI), Chen Xi (CWI No. 07072021) and Bureau Veritas Inspector, Li Wen Sheng were present during all of the above welding.

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The QA Inspector also observed that the QC Inspector was documenting the parameters as welding progressed and that the random verification by the QA Inspector essentially confirmed the QC documentation for the random sample, and that QC documentation showed compliance with the WPS's up to the time of the random sample.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Jobes, Kenneth

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer